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D3023-1

Job Sheet 205111



Part No: D3023-1

Job Qty: 2 pcs

Part Name: Back Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/19

Job Tracking No:

Due Date: 2/24/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 02.01.23 Revised NG IPP Rev:D 08-04-16 now water jet DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		1/24/20	0.17	1.08	Waterjet - Flow		on 20/02/05
110	QC 2	2 pcs		1/24/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/02/05
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	2 pcs	1/24/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	FEB 05 2020 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	2 pcs	1/24/20	0.25 0.10	Small Fab - Brake - 1 - B4B	DAS 30 FEB 15 2020 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	2 pcs	1/24/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	FEB 06 2020 9-89
				QC 5 - 61	
				QC 5 - 81	
180 Packaging 3-1 - Stock - B4B	2 pcs	1/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
190 QC 21 - SA	2	1/24/20	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	9.25
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D3023 ***graind direction along 28.100" ***
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: WA001) LOCATION: WA001
 190 - (QC21- Final Inspection - Work Order Release)

FEB 06 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	11.4000 sf (5.7 ea)	100-Waterjet - Flow - 1	5018261

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	11	93	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Back Panel	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter	
2	Back Panel	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
3	Back Panel	1.660Inches ± 0.010	1.670 1.650		
4	Back Panel	0.375Inches ± 0.010	0.385 0.365		
5	Back Panel	1.340Inches ± 0.010	1.350 1.330		
6	Back Panel	2.375Inches ± 0.010	2.385 2.365		
7	Back Panel	0.375Inches ± 0.010	0.385 0.365		
8	Back Panel	25.280Inches ± 0.030	25.310 25.250		
9	Back Panel	27.030Inches ± 0.030	27.060 27.000		
10	Back Panel	28.100Inches ± 0.030	28.130 28.070		
11	Back Panel	1.300Inches ± 0.030	1.330 1.270		
12	Back Panel	2.375Inches ± 0.010	2.385 2.365		
13	Back Panel	8.711Inches ± 0.010	8.721 8.701		
14	Back Panel	5.597Inches ± 0.010	5.607 5.587		
15	Back Panel	8.570Inches ± 0.030	8.600 8.540		
16	Back Panel	1.970Inches ± 0.010	1.980 1.960		
17	Back Panel	7.420Inches ± 0.030	7.450 7.390		
18	Back Panel	10.920Inches ± 0.030	10.950 10.890		
19	Back Panel	14.750Inches ± 0.030	14.780 14.720		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S253517



Part: D3023-1

Job No: 205111

Serial No/Batch: S253517

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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